

pointed profile adjacent the margin of the substrate sheets and superimposed surfaces of the substrate sheets on the opposite side of the pointed profile of the anvil.

61. (New) The method of Claim 60, wherein there is provided the step of flattening the welds at the longitudinal margins of the three-substrate sheets before the segments of the web before or after they are severed from the web are laminated to the other segments thereof.

62. (New) A method for forming a cellular panel for a window covering, the method comprising the steps of:

forming a plurality of tubular cells, each consisting of a first sheet and a second sheet, and each having a pair of longitudinal margins;

laminating the plurality of tubular cells.

63. (New) The method of Claim 62 wherein the step of forming the plurality of tubular cells includes:

positioning the longitudinal margins of the first sheet proximate the longitudinal margins of the second sheet

joining the first sheet to the second sheet with an ultrasonic weld along their respective longitudinal margins;

64. (New) The method of Claim 64 further including the step of reforming each tubular cell so that the welds are transitioned from the longitudinal margins to positions on top and bottom of a flat reformed cell.

65. (New) The method of Claim 64 wherein the step of reforming each tubular cell includes laterally offsetting the weld of a first tubular cell from the weld of a second tubular cell.

66. (New) The method of Claim 64 wherein the reforming of each tubular cell includes rotating the tubular cell, expanding the tubular cell, and flattening the tubular cell.

67. (New) The method of Claim 66 wherein each tubular cell is rotated by passing it through spaced apart vertical rods.

68. (New) The method of Claim 66 wherein the step of expanding each tubular cell includes passing the expanded tubular cell around an insert.

69. (New) The method of Claim 68 wherein the insert includes a roller configured to keep each tubular cell expanded in a vertical plane and a guidance plate configured to keep the tubular cell expanded in a horizontal direction.

70. (New) The method of Claim 69 further including the step of providing guidance members configured to keep the insert from shifting out of position.

71. (New) The method of Claim 68 further including the step of passing the tubular cells between a pair of stationary grooved sleeves configured to laterally offset the welds.

72. (New) The method of Claim 66 wherein the step of flattening each tubular cell includes vibrating the reformed cell against a rotating anvil having recessed portion configured to receive the welds.

73. (New) The method of Claim 62 wherein the step of laminating the plurality of tubular cells includes applying an adhesive between adjacent tubular cells and successively stacking them.

74. (New) The method of Claim 73 wherein the adhesive is applied to a top portion of a first tubular cell as a pair of spaced apart bands.

75. (New) The method of Claim 74 wherein at least one of the spaced apart bands is applied over at least one of the welds.

76. (New) The method of Claim 62 further including the step of passing the first and second sheets through a plurality of rollers configured to substantially maintain a constant tension in the first and second sheets.

77. (New) The method of Claim 76 further including the step of moving at least some of the plurality of rollers with a feedback control system.

78. (New) The method of Claim 77 wherein the plurality of rollers includes a photo-cell controlled edge guidance assembly.

79. (New) The method of Claim 62 further including the step of slitting the first and second sheets along their longitudinal margins adjacent the welds.

80. (New) The method of Claim 79 wherein the welds are formed by an anvil configured to weld the first and second sheets and slit the longitudinal edges.

81. (New) The method of Claim 62 further including the step of relieving stresses produced in the reformed cell.

82. (New) The method of Claim 62 further including the steps of cutting the web into a first strip and a second strip and positioning the first strip above the second strip.

83. (New) The method of Claim 82 wherein the positioning includes raising the second strip to adhere to the bottom portion of the first strip.

84. (New) A method for forming a cellular panel for a window covering, the method comprising the steps of:

providing a first sheet and a second sheet, each having a pair of longitudinal margins;

forming a first tubular cell by joining at least one longitudinal margin of the first sheet to at least one longitudinal margin of the second sheet;

adhering the first tubular cell to a second tubular cell.

85. (New) The method of Claim 84, further including the step of reforming the first tubular cell by rotating the first tubular cell, expanding the first tubular cell, and flattening the first tubular cell.

86. (New) The method of Claim 85 wherein the reforming step includes a step of laterally offsetting a first weld relative to a second weld.

87. (New) The method of Claim 85 further including the step of passing the expanded first tubular cell around an insert prior to being flattened.

88. (New) The method of Claim 87 further including the step of passing the first tubular cell between a pair of stationary grooved sleeves configured to laterally offset the welds.

89. (New) The method of Claim 85 wherein the flattening the first tubular cell includes vibrating the reformed first tubular cell against a rotating anvil having recessed portion configured to receive the welds.

90. (New) The method of Claim 84 wherein the adhering step includes applying a pair of spaced apart bands of adhesive.

91. (New) A method for forming a cellular panel for a window covering, the method comprising the steps of:
providing a first sheet and a second sheet;
forming a tubular cell by joining the first sheet to the second sheet;
adhering a section of the tubular cell to a previously formed section of the tubular cell.

92. (New) The method of Claim 91 wherein the first and second sheets each include longitudinal margins and wherein the first and second sheets are joined along their longitudinal margins.

93. (New) The method of Claim 92 wherein the step of joining the first and second sheets includes providing ultrasonic welds along their respective longitudinal margins.

94. (New) The method of Claim 91 wherein the first sheet is made of a first material, and the second sheet is made of a second material different than the first material.

95. (New) The method of Claim 94 further including the step of reforming the tubular cell so that the welds are transitioned from the longitudinal edges to positions on top and bottom of a flat reformed web.

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96. (New) The method of Claim 95 wherein the step of reforming the tubular cell includes rotating the tubular cell, expanding the tubular cell, and flattening the tubular cell.

REMARKS

The present application is a division of co-pending application Serial No. 09/442,090. The Applicants have cancelled original Claims 1-18, 32-35, and 38-59 without prejudice to further prosecution on the merits. Claims 60-96 have been added. The Applicant requests consideration and allowance of Claims 19-31, 36, 37, and 60-96.

Amendments to original informal FIGURES 4L, 4P, and 15-17 (shown in red ink), and to the Specification have been previously submitted and approved by the Examiner in the parent case.

The Applicants expressly disavow any and all claim amendments and remarks (including remarks directed to or about any cited reference) made in connection with the parent applications (Serial Nos. 09/442,090; 08/880,569; 08/273,469; 08/273,469), or in connection with any related application. The Applicants do not intend any prior claim amendment or remark in the parent applications or any related application to have any effect on the prosecution or scope of any claim in the present application.

No new matter has been added.